



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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RBST2812-P
Job Sheet 201318



Part No: RBST2812-P

Job Qty: 1 pcs

Part Name: Portable Tri-Roller Staking Tool



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/1/19

Job Tracking No:

Due Date: 10/31/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBST2800-P Rev. 1 IPP Rev. A 18.06.21 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	1 pcs	10/31/19		0.00	0.50	Small Fab - 1		M66
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
							Small Fab - 8		
110	QC 5	1 pcs	10/31/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
130	Packaging 3-1 - Stock - B4B	1 pcs	10/31/19		0.00	0.00	Packaging 3 - 1 - B4B		DAS OCT 1 8 2019 9-89
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		



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CANADA
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Container No: S221755



Part: RBST2812-P

Job No: 201318

Serial No/Batch: S221755

Revision: 1

Inspector:

Exp Date:

Instructions:

Date: 10/10/19

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				Packaging 3 - 5 - B4B	DAS	
				Packaging 3 - 6 - B4B	28	
				Packaging 3 - 7 - B4B	9-89	
				Packaging 3 - 8 - B4B		
				Packaging 3 - 9 - B4B		
				Packaging 3 - 10 - B4B		
				Packaging 3 - 11 - B4B		
				Packaging 3 - 12 - B4B		
				Packaging 3 - 13 - B4B		
				Packaging 3 - 14 - B4B		
				Packaging 3 - 15 - B4B		
				Packaging 3 - 16 - B4B		
				Packaging 3 - 17 - B4B		
				Packaging 3 - 18 - B4B		
				Packaging 3 - 19 - B4B		
				Packaging 3 - 20 - B4B		
				Packaging 3 - 21 - B4B		
				Packaging 3 - 22 - B4B		
				Packaging 3 - 23 - B4B		
				Packaging 3 - 24 - B4B		
				Packaging 3 - 25 - B4B		
				Packaging 3 - 26 - B4B		
				Packaging 3 - 27 - B4B		
				Packaging 3 - 28 - B4B		
				Packaging 3 - 29 - B4B		
				Packaging 3 - 30 - B4B		
				Packaging 3 - 31 - B4B		
				Packaging 3 - 32 - B4B		
				Packaging 3 - 33 - B4B		
				Packaging 3 - 34 - B4B		
				Packaging 3 - 35 - B4B		
				Packaging 3 - 36 - B4B		
140	QC 21 - FG	1 pcs	10/31/19	0.00 0.00	QC 21 - FG - 21	DAS
					QC 21 - FG - 70	21
					QC 21 - SA - 53	9-89

Part Op 100 - (Small Fab) 1-Assemble as per DWG sheet 1. ***NOTE*** - Apply a light coat of corrosion prevention compound to
 Descriptions: assembly (LPS 1/2) See deviation. See note 1 and 2.
 110 - QC5- Inspect part completeness to step on W/O
 130 - (Identify as per dwg & Stock Location: _____) Identify and Stock
 140 - (QC21- Final Inspection - Work Order Release)

Job BOM

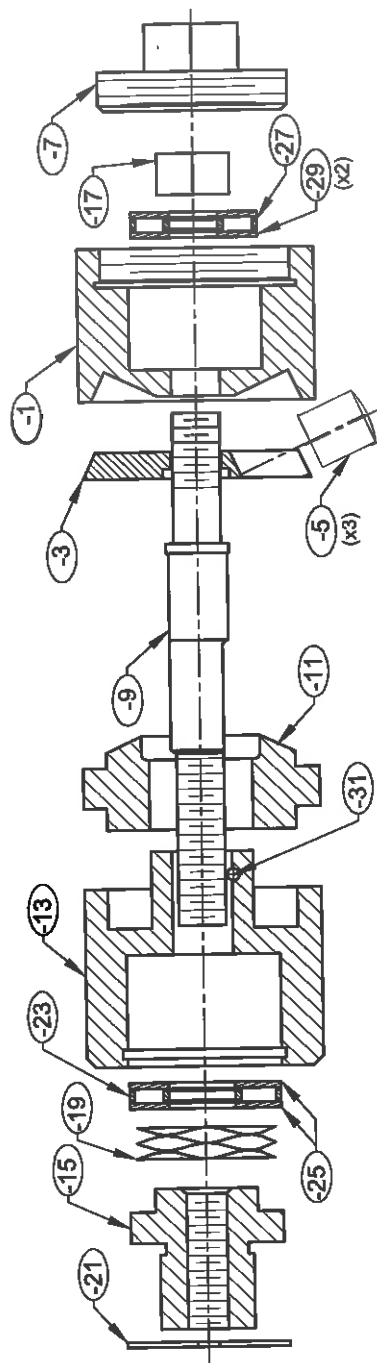
Part / Item	Component Name	Quantity	Operation	Container
54 92383A202	Roll Pin	1 pcs (1 ea)	100-Small Fab - 1	50891241
58 95065A150	Distorted Thread Lock Nut	1 pcs (1 ea)	100-Small Fab - 1	5089130
43 99142A410	Internal Snap Ring	1 pcs (1 ea)	100-Small Fab - 1	5089123
78 CS075-H1	Crest to Crest Flat Wire Wave Spring	1 Ea (1 ea)	100-Small Fab - 1	50893424
34 NTA-411	Bearing	1 Ea (1 ea)	100-Small Fab - 1	5033972
34 NTA-613	Bearing 13/16" Od X 3/8" Id (Applied)	1 Ea (1 ea)	100-Small Fab - 1	5031979
137 RBST2812-P-1	Base	1 pcs (1 ea)	100-Small Fab - 1	5121008
7 RBST2812-P-11	Dual Seat	1 pcs (1 ea)	100-Small Fab - 1	5122912
RBST2812-P-13	Receiver	1 pcs (1 ea)	100-Small Fab - 1	5124969
RBST2812-P-15	Tensioner	1 pcs (1 ea)	100-Small Fab - 1	5122415
138 RBST2812-P-3	Retainer	1 pcs (1 ea)	100-Small Fab - 1	519966
RBST2812-P-5	Roller	3 pcs (3 ea)	100-Small Fab - 1	521250
RBST2812-P-7	Cap	1 pcs (1 ea)	100-Small Fab - 1	519989
137 RBST2812-P-9	Stud	1 pcs (1 ea)	100-Small Fab - 1	5122419
36 TRA-411	Washer	2 Ea (2 ea)	100-Small Fab - 1	5033975
TRA-613	Washer 13/16" Od X 3/8" Id (Applied)	2 Ea (2 ea)	100-Small Fab - 1	5150492

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	92383A202	1	91	0
	95065A150	1	89	0
	99142A410	1	43	0
	CS075-H1	1	2	0
	NTA-411	1	31	0
	NTA-613	1	7	0
	RBST2812-P-1	1	1	0
	RBST2812-P-11	1	3	0
	RBST2812-P-13	1	3	0
	RBST2812-P-15	1	2	0
	RBST2812-P-3	1	2	0
	RBST2812-P-5	3	8	0
	RBST2812-P-7	1	2	0
	RBST2812-P-9	1	2	0
	TRA-411	2	58	0
	TRA-613	2	16	0
Part Specifications				
Specifications could not be found.				

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REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	CH'D -1, -3, -9 -11 & -13 DATUM TARGET DESIGNATIONS AND FEATURE CONTROL FRAMES. 7/26/12 RUC	7/26/12	RUC	SE
	ADDED 2ND FLAT ON -13.			



201318 MLS
19-10-01

- NOTES**
- 5 ROLLERS AND -3 RETAINER MUST TURN SMOOTHLY ON -1 BASE WHEN ASSEMBLED.
 - FLAT END OF -5 ROLLERS MUST FACE THE CENTER OF TOOL WHEN ASSEMBLED.

BEARING #	TOOL #
206-010-470-101	RBST2812-P

RED BARN MACHINE

TITLE RBST2800-P SERIES FOR BELL BEARINGS
PORTABLE TRI-ROLLER SWAGING TOOLS

ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MAT.	B/O INFORMATION OR SPECIFICATIONS	Pg.
		-1	1	BASE		SEE CHART	2
		-3	1	RETAINER		SEE CHART	3
		-5	3	ROLLER		SEE CHART	4
		-7	1	CAP		SEE CHART	5
		-9	1	STUD		SEE CHART	6
		-11	1	DUAL SEAT		SEE CHART	7
		-13	1	RECEIVER		SEE CHART	8
		-15	1	TENSIONER		SEE CHART	9
B/O		-17	1	DISTORTED THREAD LOCK NUT	STEEL	1/4-20 UNC x 7/32 HL. MCMASTER-CARR #95065A150	1
B/O		-19	1	CREST TO CREST FLAT WIRE WAVE SPRING	STEEL	.750 OD. .550 ID. WIRE THICK. .013. THREE TURNS SNALLEY RING CO. #CS075-H1	1
B/O		-21	1	INTERNAL SNAP RING	STEEL	Ø7/8 BORE MCMASTER-CARR #98142A410	1
B/O		-23	1	THRUST BEARING (SPRING SIDE)	STEEL	Ø3/8 ID. x 13/16 OD. x 5/64 WIDTH APPLIED (TIMKEN #NTA-613)	1
B/O		-25	2	BEARING WASHER	STEEL	Ø3/8 ID. x 13/16 OD. x 1/32 WIDTH APPLIED (TIMKEN #TRA-613)	1
B/O		-27	1	THRUST BEARING	STEEL	Ø1/4 ID. x 11/16 OD. x 5/64 WIDTH APPLIED (TIMKEN #NTA-411)	1
B/O		-29	2	BEARING WASHER	STEEL	Ø1/4 ID. x 11/16 OD. x 1/32 WIDTH APPLIED (TIMKEN #TRA-411)	1
B/O		-31	1	ROLL PIN	STEEL	Ø3/32 x 3/8	N/S

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED	DATE	11-9-09
TOLERANCES:	PERITT		
DECIMALS			
FRACTIONS 1/32			
ANGLES ±.01			
ANGLES ±.5°			
UNLESS OTHERWISE SPECIFIED			
1. BREAK ALL SHARP EDGES			
.015 x 45° PR .015 R			
2. DIMENSIONAL LIMITS APPLY AFTER PLATING			
SCALE			
SHEET			1 of 9

Entered: _____ Date: _____ **WORK ORDER NON-CONFORMANCE / ROUTE UPDATE**

Route update only

NCR No. _____

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) Prod. Eng. Coord. Rec/Store/Packaging	DEPARTMENT/PROCESS Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐ Eng. (Non-AW) Prod. Eng. Coord. Rec/Store/Packaging	MRB (QS1042)	Completed By	Lead hand / Supervisor	QC / QA Coordinator																																																																																																																			
Date : _____		Sequence #: _____		QTY Affected : _____																																																																																																																					
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